

Patent claims

1. A method for production of an object (10, 10') with a first layer (1), which is bonded to a second layer (2), the first layer being plastically deformable and having a front side (1a) and a rear side (1b), and the bonding of the two first layer (1, 2) taking place in an injection mold, characterized by the following method steps:
  - 10 a) the first layer (1) is partially provided with a coating (4') on its front side (1a),
  - b) the coating (4') is cured,
  - 15 c) the first layer (1) is inserted into an injection mold (6),
  - d) the first layer (1) is pressed with its front side (1a) against an inner side (7) of the injection mold (6), the cured coating (4') changing the form of the first layer (1) and at least partially creating an impression in the first layer (1),
  - 25 e) the product (10, 1d) is demolded.
2. The method as claimed in claim 1, characterized in that the coating (4') is impressed substantially completely into the first layer (1) and forms one or more depressions (3) in the latter (4').
3. The method as claimed in claim 1 or 2, characterized in that the first layer (1) is laminated in the injection mold (6) by injecting plastic behind it and the second layer (2) is thereby formed.

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4. The method as claimed in one of claims 1 to 3, characterized in that a thermoplastic is injected behind the first layer (1).  
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5. The method as claimed in one of claims 1 to 4, characterized in that the first layer (1) is provided with an adhesion promoter (8) on its rear side (1b) before the in-mold lamination.  
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6. The method as claimed in one of claims 1 to 5, characterized in that the first layer (1) is a metal foil, in particular an aluminum foil or steel foil.  
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7. The method as claimed in one of claims 1 to 7, characterized in that the thickness (D) of the first layer (1) is 0.5 mm or less, preferably 0.1 mm or less.  
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8. The method as claimed in one of claims 1 to 6, characterized in that the thickness (D) of the first layer (1) is 0.1 to 0.3 mm.  
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9. The method as claimed in one of claims 1 to 8, characterized in that the coating (4') has a thickness (H) of from 2 to 1000 micrometers, preferably 2 to 100 micrometers.  
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10. The method as claimed in one of claims 1 to 9, characterized in that the thickness (H) of the coating (4') is 4 to 10 micrometers.  
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11. The method as claimed in one of claims 1 to 10, characterized in that the coating (4') is an imprint.

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12. The method as claimed in one of claims 1 to 11, characterized in that the coating (4') is produced from one or more printing inks.
- 5 13. The method as claimed in claim 12, characterized in that the printing ink is at least partially translucent, transparent or semi-transparent.
- 10 14. The method as claimed in one of claims 1 to 13, characterized in that the coating (4') is applied by screen printing or pad printing.
- 15 15. The method as claimed in one of claims 1 to 14, characterized in that the coating (4') is cured thermally, with UV radiation, chemically or by exposure to air.
- 20 16. The method as claimed in claim 15, characterized in that the imprint (4') is cured at 70 to 100°C, preferably approximately 80°.
- 25 17. The method as claimed in one of claims 1 to 16, characterized in that the coating (4') comprises more than one layer.
- 30 18. The method as claimed in one of claims 1 to 18, characterized in that the coating (4) is at least partially removed, preferably dissolved away or pulled off.
- 35 19. The method as claimed in one of claims 1 to 18, characterized in that a decorative part or a trim molding for a motor vehicle is produced.
20. An object, produced by the method as claimed in claim 1, characterized in that the front side (1a) of the first layer (1) partially has a depression

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or depressions (3), which are deformations and in particular impressions created by a partial coating (4).

- 5 21. The object as claimed in claim 20, characterized in that the depression or depressions (3) are completely or partially filled with a printing ink.
- 10 22. The object as claimed in claim 20 or 21, characterized in that the coating (4) has an upper side (4a) which is arranged deeper than the front side (1a) of the first layer (1).
- 15 23. The object as claimed in one of claims 20 to 22, characterized in that the coating (4) is transparent or opaque.
- 20 24. The object as claimed in one of claims 20 to 23, characterized in that the coating (4) is a printing ink.
- 25 25. The object as claimed in one of claims 20 to 24, characterized in that the first layer (1) is a metal foil and has a thickness (D) which is less than 0.5 mm, preferably 0.1 to 0.3 mm.
- 30 26. The object as claimed in one of claims 20 to 25, characterized in that it is a decorative part or a trim molding for a motor vehicle.
27. The object as claimed in one of claims 20 to 26, characterized in that the second layer (2) is an injection-molded part.